

Work Order ID 56100

February 10, 2010 12:16:30 PM

Page 1

Item ID: D3523-3

Revision ID:

Item Name: Leg

Start Date: 2/10/10

Required Date: 2/26/10

Reference:

Start Qty: 6.00

Req'd Qty: 6.00

Accept

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Approvals:

Process Plan:

Date: 10-2-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3523

Rev B

100



Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

Machine as per folio FA702 & dwg D3523

0.00

0.00

SA 10/02/27

17 0

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

SA 10/02/27

17 0

120



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

Drill For Helicoil & Set-Screw

Use e-mill to pilot hole to avoid drill deviation*

0.00

0.00

SL 10/03/03

17 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3523-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Leg

Start Date: 2/10/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		2L 10/03/03		17	Ø		
140 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		MMU 10/03/04		17	Ø		
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		els 10/03/01		X17	Ø		

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Accept



Setup Start



Revision ID:

Stop



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Start Date: 2/10/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	PR 10-03-4.		(17)				
180 Mill Conv Conventional Milling Machine	CONVENTIONAL MILLING MACHINE Memo Install Helicoil as per Dwg D3523	0.00 0.00	SL 10/03/08						
190 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	S067/08		(417)				

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Item ID: D3523-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Leg

Start Date: 2/10/10 Start Qty: 6.00

Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Identify as per dwg & Stock Location: GP

0.00



Packaging

Memo

0.00

Packaging

10/3/9 (17)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/11 HJ

MF 10-3-9.

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Picklist Print

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Page 1

Work Order ID: 56100



Parent Item: D3523-3



Parent Item Name: Leg

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:A New Issue 07-06.15 EC
IPP Rev:B Added Helicoil 07-07-19 JLM Verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21209-F120		Purchased	No			100	Each	38.0000	6.0000			

HELI COIL

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST *m114037* 38
107823 38

210

Feb 10.03.03

M6061T6R1.000 Purchased No

180 f 53.0524 0.7326



ROUND BAR 1.00"

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT 53.0524
108876 8.355
110966 11.6274
113457 33.07

1.827

SA 10/02/28

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	56100
Description: Leg		Part Number:	D3523-3
Inspection Dwg: D3523 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.700	+0.008/-0.001	Ø.7025	/			
R0.13	+/-0.030	R.13	/			
Ø0.742	+0.000/-0.010	Ø.741	/			
0.350	+/-0.010	.351	/			
0.374	+/-0.010	.375	/			
0.200	+/-0.010	.2005	/			
1.140	+/-0.010	1.142	/			
90°	+/-0.5°	90°	/			
(2) 6-40 UNF	N/A	6-40 UNF	/			
0.83 deep	+/-0.030	.840	/			
Tap 10-32 Heli-Coil	N/A	/	/			
0.100	+/-0.010	.100	/			

Measured by: SA	Audited by: MNP	Prototype Approval:	N/A
Date: 10/02/27	Date: 10/02/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	DD

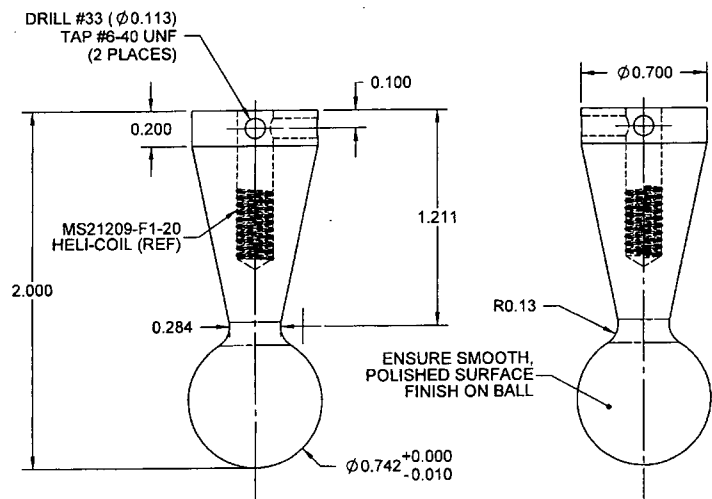
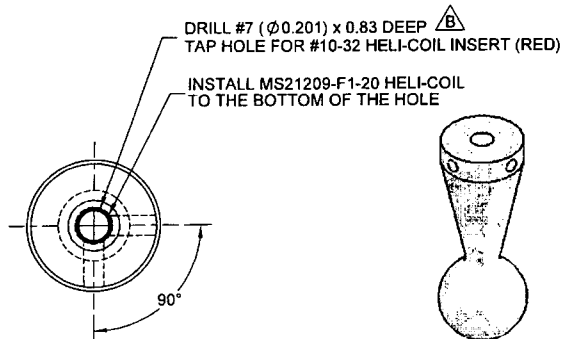
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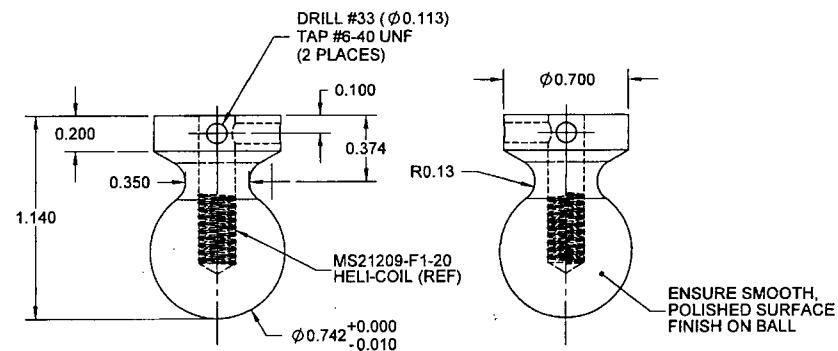
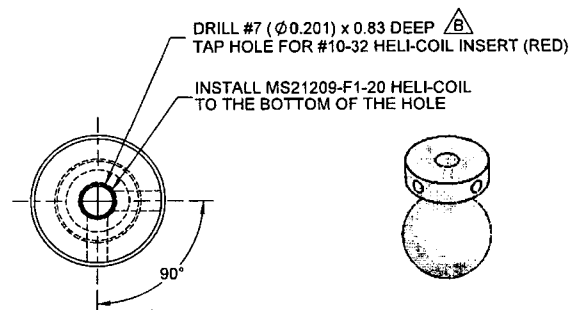
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D3523-1 LEG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54100
B10-2-10



D3523-3 LEG

RELEASED
27.08.03

$\triangle B$

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3523-1: 0.05 lbs
D3523-3: 0.03 lbs

B	ZONE D7, D3: HOLE DEPTH REVISED FROM 0.69 TO 0.83 ZONE A8: UPDATE NOTES: ADD WEIGHT UPDATE DRAWING FORMAT	CB	07.07.25
A	NEW ISSUE	CB	07.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	CB		
DRAWN	CB		
CHECKED	CB		
MFG. APPR.	CB		
APPROVED	CB		
DE APPR.	CB		
DATE	07.07.25		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3523	REV. B
TITLE LEG	SCALE 3:2
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